

Split

Work Order ID 165775-4

165775

Page 1

Monday, August 28, 2017 2:22:00 PM

Item ID: D5283-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Basket Clamp Assembly
Start Date: 8/30/2017 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 9/12/2017 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: DAS 13 Date: AUG 28 2017 Tooling: Date: Run Start *NR1*
QC: 9-89 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5283	A

100 0.00

100

Bandsaw Memo 0.45
Jeaspa Bandsaw CUT TO 5.5" LONG

FM
17/08/29

105 0.00

105

Purchasing Memo 0.00

Purchasing Issue p.o. 37611
Possible supplier: Metec
Machine, Alodine and powder Coat as per Dwg***Note mask bore prior to powder coat***

C of C is required

10 DOB

AUG 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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165775

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110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging									

10x SP179-15

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							

Quality Control *Chemical conversion* *(10) 2017-09-19 JSC BEB*
121 *QC 7*

190		0.00							
-----	--	------	--	--	--	--	--	--	--

190									
Small Fab	Memo	1.64							
Small Fab	PRESS FIT BEARING AND STAKE 4 PLACES PER SIDE AS PER DWG								

10 *SEP 18 2017* *SEP 18 2017* *4x* *17/09/20*

123 *Powder coat as per drawing white gloss (4.35.1)* *START: 11:05* *10 17-09-20*
Mask bearing bore *Q.T. 300'* *FINISH: 11:35*

124 *QC 3* *(4x) SEP 20 2017*

DQA: _____ Date: _____



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Work Order ID 165775

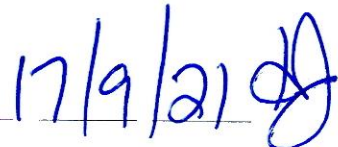
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	0	SEP 20 2017	DAS 9 9-89
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>56523</u> Memo	0.00 0.00				4		SEP 20 2017	DAS 6 9-89
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						17/9/21	

SEP 20 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Picklist Print

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Work Order ID: 165775

165775

Parent Item: D5283-043

D5283-043

Parent Item Name: Basket Clamp Assembly

Start Date: 8/30/2017

Required Date: 9/12/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 15.07.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611 *D2611* Bearing		Manufactured	No			190	Each	9.0000	1	10			
									**			17/09/20	DAS 38 9-89
D5283-3P *D5283-3P* Basket Clamp		Purchased	No			105	Each	0.0000	1	10			
									**				10x80A9-15
M6061T6B30000X01.5 00 *M6061T6B.30000X01 500* 6061-T6 Bar 3.00 x 1.50		Purchased	No			100	f	8.0000	0.46	4.842105			
									**				

Location

Loc Qty

Loc Code

MAT004

8

m135559 x7

8

M134984x2

~~3.20~~
3.20
.46

M6061T6B 1.500 x 1.000 M132797 .46

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

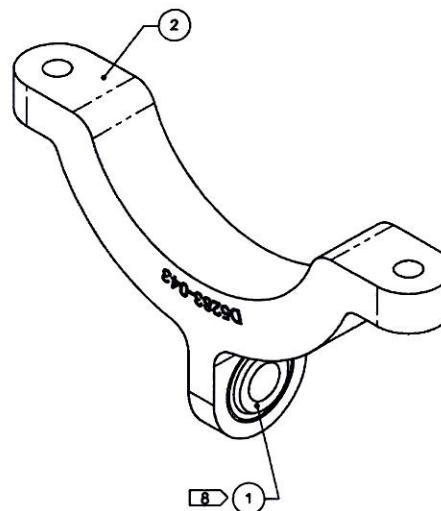
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY	P/N	DESCRIPTION
	X	D5283-043	BASKET CLAMP ASSY
1	1	D2611	BEARING
2	1	D5283-3	BASKET CLAMP

AUG 28 2017

DAS
13
9-89

W/O: 165775



D5283-043 BASKET CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) PRESS FIT D2611 BEARING AND STAKE 4 PLACES PER SIDE

RELEASED
2015-07-20

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5283	SHEET 2 OF 6
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	BASKET CLAMP ASSY	NTS
DATE		15.06.30	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37611**

Purchase Order Date 8/30/2017

PO Print Date 9/1/2017

Page Number 1 of 3

Order From :
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Revised.

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D5283-1P	Basket Clamp	9/12/2017 Yes 9/12/2017	FN	10.00 Each	\$14.75	\$147.50
	Machine as per Dwg D5283 Rev. A B165774 NO ALODINE AND POWDER COAT						
Line Total:							\$147.50
2	D5283-3P	Basket Clamp	9/12/2017 Yes 9/12/2017	FN	10.00 Each	\$28.75	\$287.50
	Machine as per Dwg D5283 Rev. A B165775 NO ALODINE AND POWDER COAT						
Line Total:							\$287.50

Note:

9/1/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21854
Date: Sep 14, 2017
Page: 1

Sold to:**Dart Aerospace Ltd.**

Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Ship to:

Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Order No.: 37611**Sold By:** Walz, Christian D.**Shipped By:** your truck**Ship Date:** Sep 14, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5283-1 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	
D5283-3 Basket Clamp, no finishing Set-up fee for quantities below 25 pcs.	Each	10	10	
	Each	1	1	
D5283-11 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	
D5283-7 Basket Clamp, no finishing no set up fee, will be done at the same time as PO 37426	Each	10	10	

SPR 9-15

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>		<u>P.O. NUMBER</u>
10	D5283-1P	Basket Clamp	Material B165774	37611
✓10	D5283-3P ✓	Basket Clamp	Material B165775	37611
10	D5283-11P	Basket Clamp	Material B165778	37611
10	D5283-7P	Basket Clamp	Material B165779	37611

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, September 14, 2017